



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
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Tel (613) 632-5200
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012592

K642-512
Job Sheet 201412



Part No: K642-512

Job Qty: 2 pcs

Part Name: Saddle



Part Weight: 0 lbs

Job Created: 10/3/19

Due Date: 10/30/19

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV Q IPP Rev:A 05.06.07 new issue EC IPP Rev.B 05.02.08, Per ECN1080P

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	2 pcs	10/30/19	10/30/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

Container No: S227739

Part: K642-512

Job No: 201412

Serial No/Batch: S227739

Revision:

Inspector:

Exp Date:

Instructions:

Date: 10/29/19

Plex 10/3/19 9:14 AM Dart.lajeunesse.marie

120 QC 4	2 pcs	10/30/19	0.00 0.00	Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
				QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
				QC 4 - 78	
130 Packaging 3-1 - Stock - B4B 2 pcs		10/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	2 pcs	10/30/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
140 QC 21 - SA	2 pcs	10/30/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAS
78
9-89
NOV 06 2019

DAS
78
9-89
NOV 06 2019

DAS
21
9-89
NOV 07 2019

DAS
21
9-89
NOV 07 2019

Part Op 110 - (Pick Kit)
 Descriptions: 120 - (QC4- 100% Inspect kits for completeness)
 130 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP K642-512

Location:

135 - (Document Control) Create White labels per PPP K642-512 CHG006

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C35A	Bolt	6 Ea (3 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
AN3C36A	Bolt	18 Ea (9 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
AN3C41A	Bolt	16 Ea (8 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
AN4C6A	Bolt	24 Ea (12 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
AN5C11A	Bolt	16 Ea (8 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
AN5C12A	Bolt	8 Ea (4 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
AN5C13A	Bolt	8 Ea (4 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
AN5C15A	Bolt	2 Ea (1 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
AN5C32A	Bolt	4 Ea (2 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
AN5C34A	Bolt	4 Ea (2 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
AN5C35A	Bolt	2 Ea (1 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D206-648-013	Ground Handling Wheel Modification	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D2652	Bushing	32 pcs (16 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D2712	Set Screw	20 pcs (10 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D2932-2	Saddle RH Out, 206	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D2933-2	Saddle RH In, 206	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D2934	Saddle Spacer	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D2935	Saddle Spacer	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D2938-2	Saddle RH Out, 206	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D2939-2	Saddle RH In, 206	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D3396-3	Bushings B	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D3407-043	Tow Ring	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D3456-1	Washer	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D3457-1	Washer	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D3672-1	Washer, Phenolic	48 pcs (24 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D3672-3	Washer, Phenolic	48 pcs (24 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
D3672-7	Washer, Phenolic	48 pcs (24 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
MS21043-3	Nut	40 Ea (20 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
MS21043-4	Nut	26 Ea (13 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
MS21043-5	Nut	8 Ea (4 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
NAS1149C0332R	Washer (AN960C10L)	48 Ea (24 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
NAS1149C0432R	Washer (AN960C416L)	48 Ea (24 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1
NAS1149C0532R	Washer (AN960C516L)	16 Ea (8 ea)	110-Packaging 1 - Pick Kit	51095415 5160270x1

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3C35A	6	26	0
	AN3C36A	18	186	0
	AN3C41A	16	315	0
	AN4C6A	24	498	0
	AN5C11A	16	90	0
	AN5C12A	8	36	0
	AN5C13A	8	25	0
	AN5C15A	2	22	0
	AN5C32A	4	28	0
	AN5C34A	4	95	0
	AN5C35A	2	45	0
	D206-648-013	2	2	0
	D2652	32	169	0
	D2712	20	289	0
	D2932-2	2	3	0
	D2933-2	2	7	0
	D2934	4	50	0
	D2935	4	60	0
	D2938-2	2	3	0
	D2939-2	2	8	0
	D3396-3	4	48	0
	D3407-043	2	7	0
	D3456-1	2	151	0
	D3457-1	4	78	0
	D3672-1	48	1,411	0
	D3672-3	48	44	0
	D3672-7	48	865	0
	MS21043-3	40	978	0
	MS21043-4	26	509	0
	MS21043-5	8	111	0
	NAS1149C0332R	48	4,125	0
	NAS1149C0432R	48	1,232	0
	NAS1149C0532R	16	164	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ Cross tube ☐ ☐ ☐ Eng. (Non-AW) Machining ☐ ☐ ☐ Small Fab ☐ ☐ ☐ Prod. Eng. Coord. Large Fab ☐ ☐ ☐ Finishing ☐ ☐ ☐ Rec/Store/Packaging Engineering ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐				Date : _____ Sequence #: _____		MRB (QS1042)																																																																					
Description Work Order Deviation				Disposition																																																																											
Root Cause <table border="1"> <tr> <td>Operator</td> <td>☐</td> </tr> <tr> <td>Manufacturing Process</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> </tr> <tr> <td>Handling/Preservation</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> </tr> <tr> <td>Product Improvement</td> <td>☐</td> </tr> <tr> <td>Process Improvement</td> <td>☐</td> </tr> <tr> <td>Human Factors</td> <td>☐</td> </tr> </table>				Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>☐</td> <td>Contamination</td> <td>☐</td> <td>Power Loss/Surge</td> <td>☐</td> <td>Positioned Wrong</td> <td>☐</td> </tr> <tr> <td>Bending</td> <td>☐</td> <td>Misaligned/off center</td> <td>☐</td> <td>Folio/Program</td> <td>☐</td> <td>Outside Tolerance</td> <td>☐</td> </tr> <tr> <td>Crushing</td> <td>☐</td> <td>BOM/Route</td> <td>☐</td> <td>Grain Direction</td> <td>☐</td> <td>Drawing</td> <td>☐</td> </tr> <tr> <td>Cracks</td> <td>☐</td> <td>Broken/Damage/Defect</td> <td>☐</td> <td>Weld</td> <td>☐</td> <td>Finish</td> <td>☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>☐</td> <td>Incomplete/Unclear Instructions</td> <td>☐</td> <td>Wrong Stock Pulled</td> <td>☐</td> <td>Part Lost/Missing</td> <td>☐</td> </tr> <tr> <td>Marks/Chatter</td> <td>☐</td> <td>Drill Holes</td> <td>☐</td> <td>Out of Sequence</td> <td>☐</td> <td>Misread</td> <td>☐</td> </tr> <tr> <td>Mislabeled</td> <td>☐</td> <td>Fit/Function</td> <td>☐</td> <td>Off-set/Set-up</td> <td>☐</td> <td></td> <td></td> </tr> </table>				Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐		
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Other/Details: _____																																																																															
Completed By _____				Lead hand / Supervisor _____																																																																											
QC / QA Coordinator _____																																																																															

4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -611	QTY -612	QTY -615	QTY -616	QTY -641	QTY -657	QTY -649	QTY -651	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-557	WEARSHOE KIT (REPLACES -547 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		AN3C4A	* BOLT ⁽¹⁾
5A					2			2		NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6				1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7				1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8				1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9				1						D2939-2	SADDLE, AFT IN, RH
10	8		8							AN3C41A	BOLT
11	16		16	16						D2646	BUSHING
12A	8		8	8						MS21043-3-3	NUT
12B	16		16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4		4	4						AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4		4	4						AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8		8	8						NAS1149C0532R	WASHER (OR AN960C516L)
15B	8		8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12		12	12						AN4C6A	BOLT
17A	24		24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24		24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12		12	12						MS21043-3-3	NUT
20A					9	9				D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1				D4956-15	* WEARSHOE ⁽¹⁾ (REPLACES D3535-15 + D3536-15)
23A					1	1				D4956-23	* WEARSHOE ⁽¹⁾ (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-39	* WEARSHOE ⁽¹⁾ (REPLACES D3535-39 + D3536-39)
25A					1	1				D4956-35	* WEARSHOE ⁽¹⁾ (REPLACES D3535-35 + D3536-35)
26A			8	8	78	78	8			AN3C4A	* BOLT ⁽¹⁾
26B			8	8	78	78	8			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1		1	1						D3407-013	TOW RING
32A	1		1	1						D3456-1	WASHER
32B	2		2	2						D3457-1	WASHER
33	1		1	1						MS21043-3-3	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10		10	10						D2713	SET SCREW
38	2		2	2						D2934	SADDLE SPACER
39	2		2	2						D2935	SADDLE SPACER

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Revision: Q

Date: 13.08.12

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -557	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-3	NUT
80							1	1		D4368-041	FWD WEARPLATE ASSY
81							1	1		D4368-043	AFT WEARPLATE ASSY
82A							1	1		D4383-1	WEARPAD
82B							1	1		D4383-3	WEARPAD
83							20	20		D3873-3	BUSHING
84								24		D3411-3	WASHER
85							2			D3275-1	SPACER
86A							6	6		AN3C40A	BOLT
86B							2	2		AN3C37A	BOLT
86C							2	2		AN3C36A	BOLT
87							10	10		MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE
 (2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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